

Work Order ID 84595

May-16-12 3:31:38 PM

\*84595\*

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Ship JUNE 1

Item ID: D4030-041 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Long Basket Assembly (350)  
 Start Date: 16/05/2012 Start Qty: 1.00 \*1\* Cust Item ID:  
 Required Date: 30/05/2012 Req'd Qty: 1.00 \*1\* Customer:  
 Reference:

Approvals: Process Plan: MLJ Date: 12/05/12 Tooling: Date: Run Start \*NR1\*  
 QC: Date: SPC (Y/N): Date: Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4030	C								
100	Pick Kit	0.00							
*100*									
Packaging	Memo	0.00							
Packaging									
110	Assemble as per dwg	0.00							
*110*									
HandFinish	Memo	0.00							
Hand Finishing	****Mask label plate to size of D4086 label, use scotchbrite red pad to lightly sand area for label, apply label ****								
120	QC5- Inspect part completeness to step on W/O	0.00							
*120*									
QC	Memo	0.00							
Quality Control									

1447310

1 0 BLDG 1

(X)

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

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Work Order ID: 84595

**\*84595\***

Parent Item: D4030-041

**\*D4030-041\***

Parent Item Name: Long Basket Assembly (350)

Start Date: 16/05/2012

Required Date: 30/05/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue DD 10.03.23 verified by:EC IPP Rev:B as  
per dwg revB DD 10.04.20 verified by:EC IPP Rev:C as per dwg  
revC DD 10.08.18 verified by:EC IPP Rev D 12.03.27 per NCR12-  
1239 EC verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4086-200 <b>*D4086-200*</b> Placard, Max Load		Manufactured	No				Each	9.0000		1			
**													
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				ST093			9						
				72051			1						
				82827			8						
D2530 <b>*D2530*</b> Handle Weldment		Manufactured	No			100	Each	1.0000	1	1			
**													
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				ST506			1						
				82895			1						
D2535 <b>*D2535*</b> Spring		Manufactured	No			100	Each	85.0000	2	2			
**													
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				ST504			85						
				83545			85						
D2537 <b>*D2537*</b> Bushing		Manufactured	No			100	Each	52.0000	2	2			
**													
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				ST504			52						
				82896			52						

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Parent Item: D4030-041

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Parent Item Name: Long Basket Assembly (350)

Start Date: 16/05/2012

Required Date: 30/05/2012

Start Qty: 1.00

Required Qty: 1.00

D3913-041

Manufactured No

84596

100

Each

0.0000

1

1

**\*D3913-041\***

Long Basket Base Assembly, 350

\*\*

1

BL 12-6-4

D3914-041

Manufactured No

84598

100

Each

0.0000

1

1

**\*D3914-041\***

Long Basket Lid Assembly (350)

\*\*

1

BL 12-6-1

D3917-3

Manufactured No

84598

100

Each

23.0000

6

6

**\*D3917-3\***

Washer

\*\*

6

BL 12-6-1

Location

Loc Qty

Loc Code

ST070

85028

23

76956

4

80598

1

81205

1

82936

17

D3953-3

Manufactured No

100

Each

29.0000

2

2

**\*D3953-3\***

Gas Spring Stud, Lid

\*\*

2

BL 12-6-1

Location

Loc Qty

Loc Code

ST075

29

82939

29

D3953-7

Manufactured No

100

Each

39.0000

2

2

**\*D3953-7\***

Spring Spacer

\*\*

2

BL 12-6-1

Location

Loc Qty

Loc Code

ST075

39

82940

39

82940

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Parent Item: D4030-041

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Parent Item Name: Long Basket Assembly (350)

Start Date: 16/05/2012

Required Date: 30/05/2012

Start Qty: 1.00

Required Qty: 1.00

D3953-9 Manufactured No

100 Each

48.0000

2

2

\*\*

**\*D3953-9\***

Gas Spring Washer

Location

Loc Qty

Loc Code

ST075

48

82035

8

82941

40

82035

D3953-17 Manufactured No

100 Each

33.0000

2

2

\*\*

**\*D3953-17\***

Gas Spring Spacer

Location

Loc Qty

Loc Code

ST075

33

82937

33

82937

D3953-19 Manufactured No

100 Each

43.0000

1

1

\*\*

**\*D3953-19\***

Gas Spring Bracket

Location

Loc Qty

Loc Code

ST075

43

82938

43

82938

D3953-21 Manufactured No

100 Each

8.0000

1

1

\*\*

**\*D3953-21\***

Gas Spring Bracket

Location

Loc Qty

Loc Code

ST075

8

81207

2

81456

6

81456

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**Dart Aerospace Ltd**

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Parent Item Name: Long Basket Assembly (350)

Start Date: 16/05/2012

Required Date: 30/05/2012

Start Qty: 1.00

Required Qty: 1.00

D3969-3

Manufactured No

100

Each

51.0000

1

1

**\*D3969-3\***

Spring (Basket Lid)

\*\*

Location

Loc Qty

Loc Code

ST272

51

64285

1

81887

10

82942

40

81887

AN3-14A

Purchased

No

100

Each

105.0000

4

4

**\*AN3-14A\***

Bolt

\*\*

Location

Loc Qty

Loc Code

ST352

105

121415

30

121444

25

121708

50

121415

AN3-16A

Purchased

No

100

Each

129.0000

2

2

**\*AN3-16A\***

Bolt

\*\*

Location

Loc Qty

Loc Code

ST352

129

117441

47

118628

1

120986

31

121708

50

120986

**Dart Aerospace Ltd**

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**\*84595\***

Parent Item: D4030-041

**\*D4030-041\***

Parent Item Name: Long Basket Assembly (350)

Start Date: 16/05/2012

Required Date: 30/05/2012

Start Qty: 1.00

Required Qty: 1.00

AN5-17A

Purchased

No

100

Each

104.0000

4

4

**\*AN5-17A\***

Bolt

\*\*

Location

Loc Qty

Loc Code

338

20

121181

20

ST338

84

117872

34

121541

50

121541/21 24

AN4-12

Purchased

No

100

Each

68.0000

3

3

**\*AN4-12\***

Bolt

\*\*

Location

Loc Qty

Loc Code

ST357

68

118626

1

119775

17

121652

50

119775

AN310-4

Purchased

No

100

Each

53.0000

3

3

**\*AN310-4\***

NUT

\*\*

Location

Loc Qty

Loc Code

ST344

53

120124

1

120518

25

121011

1

121349

25

121444

1

120518

14/3/10

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**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
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Parent Item: D4030-041

**\*D4030-041\***

Parent Item Name: Long Basket Assembly (350)

Start Date: 16/05/2012

Required Date: 30/05/2012

Start Qty: 1.00

Required Qty: 1.00

AN310C4

Purchased

No

100

Each

53.0000

2

2

**\*AN310C4\***

Nut

\*\*

Location

Loc Qty

Loc Code

ST344

53

120360

28

121166

3

121444

22

120360

MS21042L3

Purchased

No

100

Each

2,596.000

6

6

**\*MS21042L3\***

Nut

\*\*

Location

Loc Qty

Loc Code

ST300

2596

117885

32

119017

1114

119075

138

121349

379

121444

933

121379

MS21042L5

Purchased

No

100

Each

1,529.000

4

4

**\*MS21042L5\***

Nut

\*\*

Location

Loc Qty

Loc Code

300

500

121652

500

ST300

1029

116105

5

116548

43

117611

18

119109

963

119109

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**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
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Work Order ID: 84595

**\*84595\***

Parent Item: D4030-041

**\*D4030-041\***

Parent Item Name: Long Basket Assembly (350)

Start Date: 16/05/2012

Required Date: 30/05/2012

Start Qty: 1.00

Required Qty: 1.00

MS24665-151

Purchased

No

100

Each

223.0000

3

3

**\*MS24665-151\***

Cotter Pin

\*\*

Location

Loc Qty

Loc Code

ST309

223

17566

223

MS24665-300

Purchased

No

100

Each

163.0000

2

2

**\*MS24665-300\***

Cotter Pin

\*\*

Location

Loc Qty

Loc Code

GA

159

118234

159

ST309

4

116823

4

NAS1149F0432P

Purchased

No

100

Each

960.0000

6

6

**\*NAS1149F0432P\***

Washer

\*\*

Location

Loc Qty

Loc Code

ST275

960

121255

2

121350

956

121415

2

NAS1149F0563P

Purchased

No

100

Each

996.0000

4

4

**\*NAS1149F0563P\***

Washer

\*\*

Location

Loc Qty

Loc Code

ST275

996

121350

996

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Parent Item: D4030-041

**\*D4030-041\***

Parent Item Name: Long Basket Assembly (350)

Start Date: 16/05/2012

Required Date: 30/05/2012

Start Qty: 1.00

Required Qty: 1.00

NAS1149F0332P

Purchased

No

100

Each

524.0000

8

8

**\*NAS1149F0332P\***

**\*\***

WASHER

Location

Loc Qty

Loc Code

ST275

524

117735

13

119225

10

120986

200

121259

200

121584

50

121585

48

17317

3

121585

NAS1149C0432R

Purchased

No

100

Each

4,244.000

2

2

**\*NAS1149C0432R\***

**\*\***

Washer

Location

Loc Qty

Loc Code

ST297

1280

117291

280

119124

1000

ST298

2964

121255

2964

121255

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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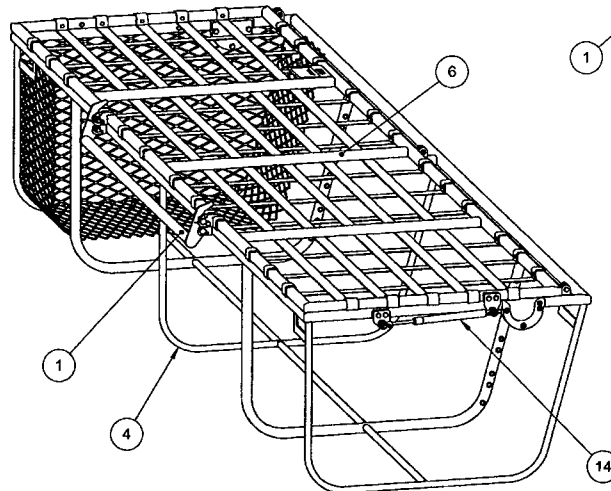
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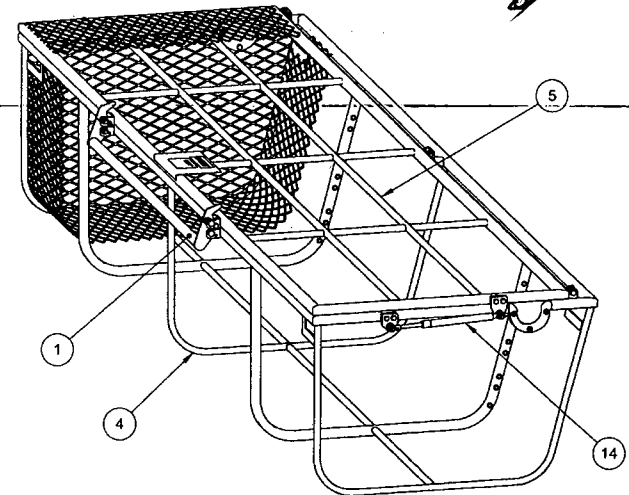
ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
	X		D4030-041	LONG BASKET ASSY (350)
		X	D4030-043	LONG BASKET ASSY, LIGHT LID (350)
1	1	1	D2530	HANDLE WELDMENT
2	2	2	D2535	SPRING
3	2	2	D2537	BUSHING
4	1	1	D3913-041	LONG BASKET BASE ASSY (350)
5	1		D3914-041	LONG BASKET, LID ASSY (350)
6		1	D3915-041	LIGHT LID ASSY-LONG BASKET
7	6	6	D3917-3	WASHER
8	2	2	D3953-3	GAS SPRING STUD, LID
9	2	2	D3953-7	GAS SPRING SPACER
10	2	2	D3953-9	GAS SPRING WASHER
11	2	2	D3953-17	GAS SPRING SPACER
12	1	1	D3953-19	GAS SPRING BRACKET
13	1	1	D3953-21	GAS SPRING BRACKET
14	1	1	D3969-3	SPRING
15	4	4	AN3-14A	BOLT
16	2		AN3-16A	BOLT
17		2	AN3-20A	BOLT
18	3	3	AN4-12	BOLT (DRILLED)
19	4	2	AN5-17A	BOLT
20		2	AN5-21A	BOLT
21	3	3	AN310-4	NUT, CASTELLATED
22	2	2	AN310C4	NUT, CASTELLATED
23	6	6	MS21042L3	NUT
24	4	4	MS21042L5	NUT
25	3	3	MS24665-151	COTTER PIN
26	2	2	MS24665-300	COTTER PIN
27	6	6	NAS1149F0432P	WASHER
28	4	4	NAS1149F0563P	WASHER
30	8	8	NAS1149F0332P	WASHER
31	2	2	NAS1149C0432R	WASHER

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT

WITHOUT NOTICE  
WORK ORDER  
NO. 24595 MLJ  
12/05/16



**D4030-043 LONG BASKET ASSY, LIGHT LID (350)**  
(MESH SHOWN LOCALLY FOR CLARITY)



**D4030-041 LONG BASKET ASSY (350)**  
(MESH SHOWN LOCALLY FOR CLARITY)

NOTES:  
1) MATERIAL: N/A  
2) FINISH: NONE  
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) UNITS: INCHES UNLESS OTHERWISE NOTED  
5) BREAK SHARP EDGES: N/A  
6) IDENTIFICATION: N/A  
7) WEIGHT: -041: 72 lbs APPROX  
-043: 57 lbs APPROX

RELEASED  
10-08-12  
ECN 10-596

C	QTY FOR ITEMS #30 & #31 UNDER -043 WERE MISSING (B8-1); QTY FOR ITEM #3 WAS 4 (D8-1). ONLY 2 ARE REQUIRED, AFFECTS SECTION C-C (D3-3).	MB	10.07.23
B	AN5-21A BOLT WAS AN5-19A: BOM & (D3-3)	JPH	10.04.06
A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS		
DRAWN			
CHECKED			
MFG. APPR.	JFS		
APPROVED			
DE APPR.			
DATE	10.07.23		

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA  
DRAWING NO. **D4030** REV. C  
SHEET 1 OF 3  
TITLE **LONG BASKET ASSY (350)** SCALE NTS  
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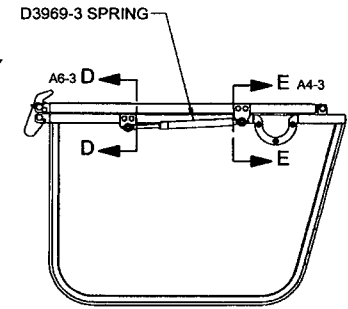
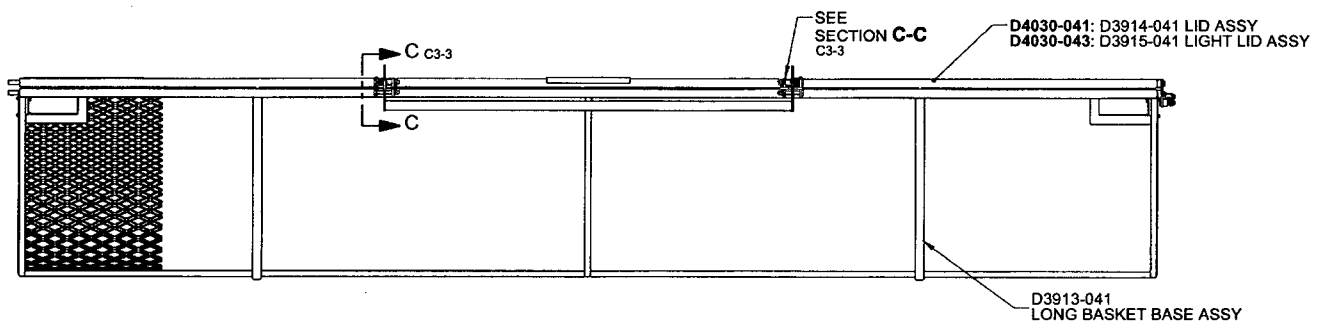
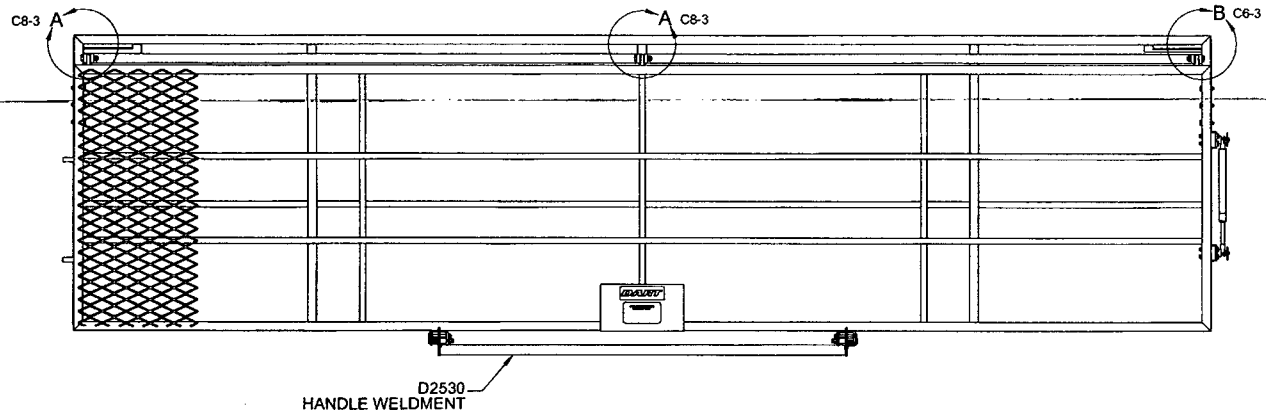
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

8 7 6 5 4 3 2 1

24595



**D4030-041 LONG BASKET ASSY (350)** (SHOWN)  
(MESH SHOWN LOCALLY OR REMOVED FOR CLARITY)

**D4030-043 SHORT BASKET ASSY. LIGHT LID (350)**  
(MESH SHOWN LOCALLY FOR CLARITY)

**RELEASED**  
10.08.17

DESIGN	AJS	<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.	SES	D4030	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET ASSY (350)	NTS
DATE	10.07.23	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

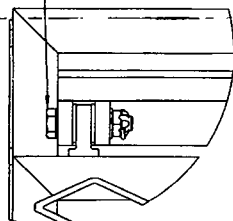
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

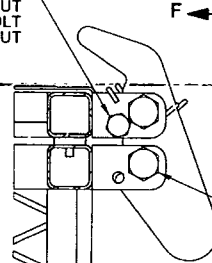
**NOTE:** Date & initial all entries

AN4-12 BOLT  
D3917-3 WASHER, 2X  
NAS1149F0432P WASHER, 2X  
AN310-4 NUT, CASTELLATED  
MS24665-151 COTTER PIN



**DETAIL A** D8-2  
D5-2

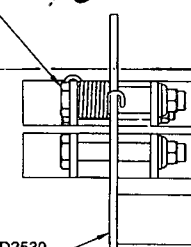
D4030-041: AN3-16A BOLT  
MS21042L3 NUT  
D4030-043: AN3-20A BOLT  
MS21042L3 NUT



**SECTION C-C** B4-2  
B6-2

D4030-041: AN5-17A BOLT  
D2537 BUSHING  
D2535 SPRING  
NAS1149F0563P WASHER  
MS21042L5 NUT

D4030-043: AN5-21A BOLT  
D2537 BUSHING  
D2535 SPRING  
NAS1149F0563P WASHER  
MS21042L5 NUT



**VIEW F-F** C3-3

D2530  
HANDLE WELDMENT  
REF

D3953-17 GAS SPRING SPACER  
D3953-21 GAS SPRING BRACKET  
AN3-14A BOLT  
NAS1149F0332P WASHER, 2X  
MS21042L3 NUT  
2 PL

D3953-3 GAS SPRING STUD, LID  
D3953-7 GAS SPRING SPACER  
D3953-9 GAS SPRING SPACER  
NAS1149C0432R WASHER  
AN310C4 NUT, CASTELLATED  
MS24665-300 COTTER PIN

D3969-3 SPRING  
REF

**SECTION D-D** B2-2

D3953-17 GAS SPRING SPACER  
D3953-19 GAS SPRING BRACKET  
AN3-14A BOLT  
NAS1149F0332P WASHER, 2X  
MS21042L3 NUT  
2 PL

D3953-3 GAS SPRING STUD, LID  
D3953-7 GAS SPRING SPACER  
D3953-9 GAS SPRING SPACER  
NAS1149C0432R WASHER  
AN310C4 NUT, CASTELLATED  
MS24665-300 COTTER PIN

D3969-3 SPRING  
REF

**SECTION E-E** B1-2

**RELEASED**  
10.08.124

DESIGN	1.5	<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.	J.F.S. BTLA	<b>D4030</b>	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		<b>LONG BASKET-ASSY (350)</b>	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries